

Work Order ID 59076



Page 1

May 26, 2010 8:46:51 AM

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 5/26/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3281	DEO E-1
-------	---------

100 0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

DL 10/05/26
RB

105 0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240 F
Time IN: 4:30 pm 10/05/25
Time OUT: 2:00 am 10/05/26

BB 10/05/25
DL 10/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59076

May 26, 2010 8:46:52 AM



Page 2

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 5/26/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3281 and Folio FTA 010								
	Dwg. Rev. <u>E</u>								
	Folio Rev. <u>D</u>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
130		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions								

Whe 10/05/26
(X3)Whe 10/05/26
(X3)Whe 10/05/27
(X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59076

May 26, 2010 8:46:52 AM



Page 3

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 5/26/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

B
10/05/27

150	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

S 10/05/27

x3

160	Packaging	0.00							
-----	-----------	------	--	--	--	--	--	--	--



Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging

10.5.28 sd (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59076

May 26, 2010 8:46:53 AM



Page 4

Item ID: D3281-4L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 5/26/10 Start Qty: 3.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

MF

10-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 26, 2010 8:46:51 AM

Page 1

Work Order ID: 59076

Parent Item: D3281-4L08

Parent Item Name: Floor Protector, Aft RH

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Start Date: 5/26/10

Required Date: 5/28/10

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No				sf	2,670.830	5	15.78947			



Lexan Sheet

Location

Loc Qty

Loc Code

therm

2670.83

2670.83

113127

12.78 38 ft. DL. 10/05/26.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 59076
Description: Floor Protector, Aft RH		Part Number: D3281-4
Inspection Dwg: D3281	Rev: DE DR 10/05/26	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

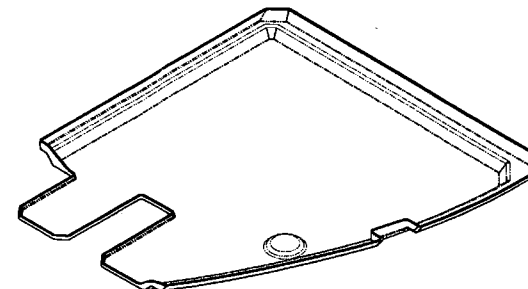
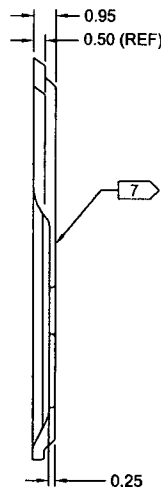
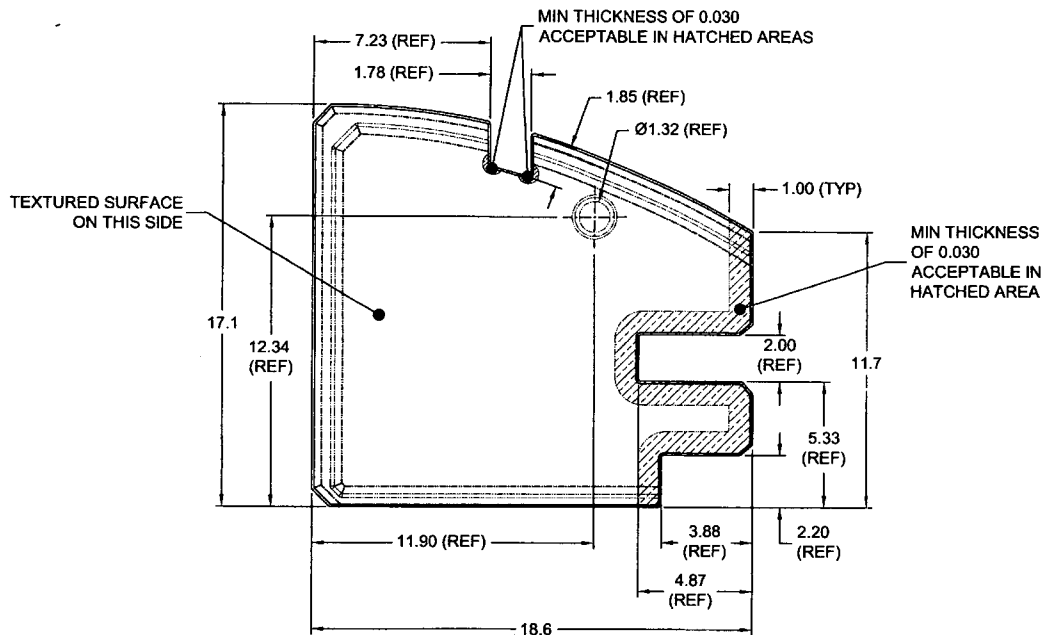
Measured by: Jhe	Date: 10/05/26
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75"	✓			
17.1	+/-0.100	17.00"	✓			
14.3	+/-0.100	14.25"	✓			
0.95	+/-0.030	0.975"	✓			
0.25	+/-0.030	Delete				
3.1	+/-0.100	Delete				
0.050	Min	0.063	✓			
0.070	Min	0.099	✓			

Measured by: Jhe	Date: 10/05/26
Audited by: BR	Date: 10/05/27
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL JA	Jhe



WQ9076

DEO ATTACHED
RELEASED
2010-02-03
mp

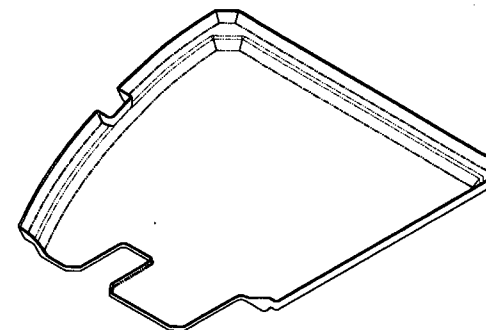
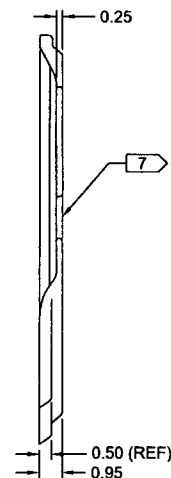
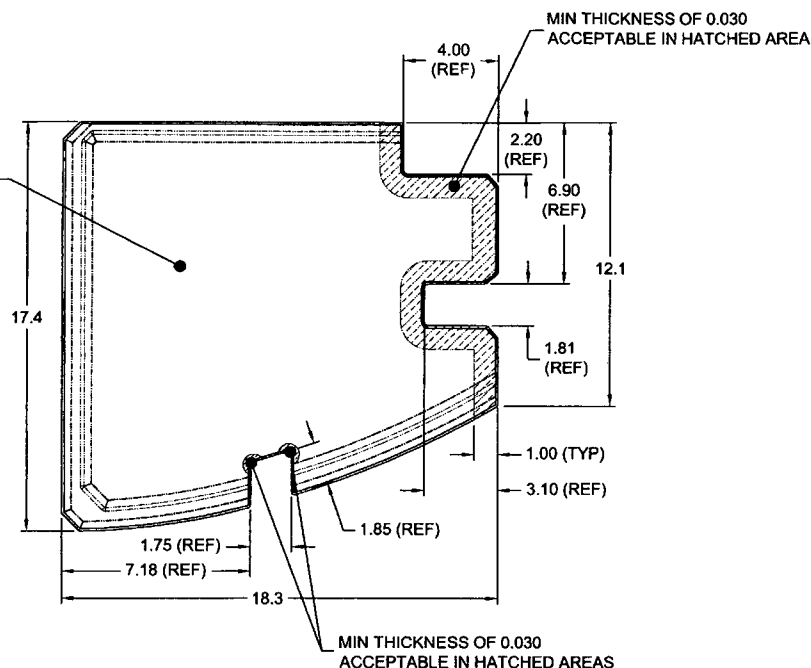
D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022: TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

E	-3/4 NOW TRIMMED FLAT: RMV 0.25 BEVEL TO FACILITATE TRIMMING (ZN D6-3, D4-4)	CP	10.01.05
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700: GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D3281	SHEET 1 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	FLOOR PROTECTOR	NTS
DATE	10.01.05	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

TEXTURED SURFACE
ON THIS SIDE



WLO 59076

D3281-2 FLOOR PROTECTOR

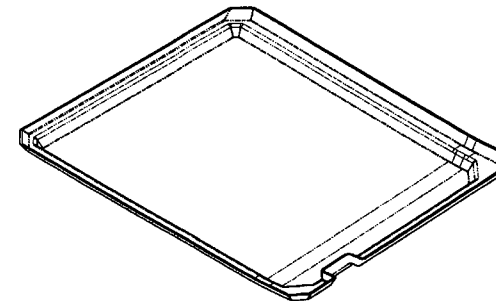
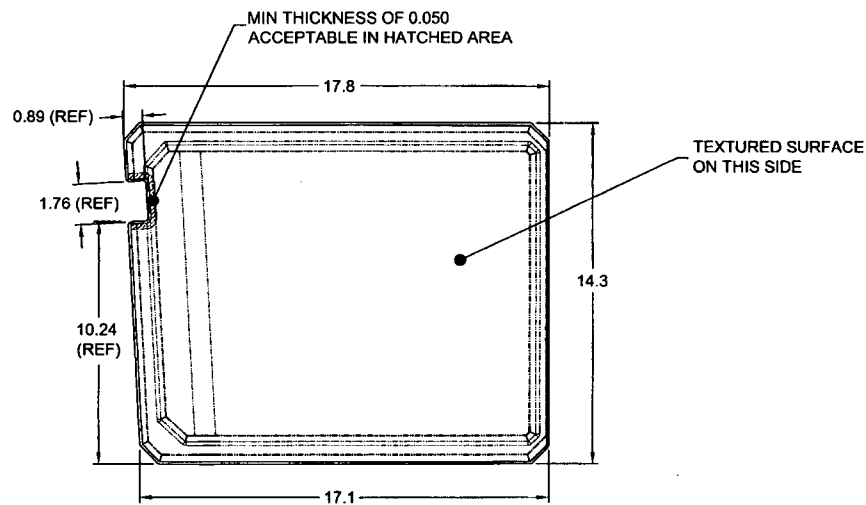
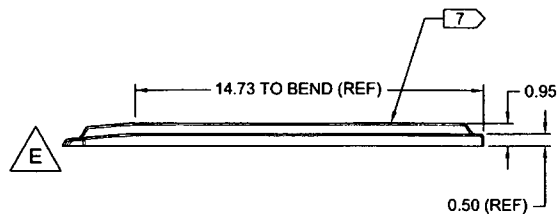
D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

DEO ATTACHED

RELEASED
2010-02-03

DESIGN	93	DART AEROSPACE LTD	
DRAWN	04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. E
MFG. APPR.	04	D3281	SHEET 2 OF 4
APPROVED	04	TITLE	SCALE
DE APPR.	04	FLOOR PROTECTOR	NTS
DATE	10.01.05	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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who says







DEO ATTACHED

RELEASED
2010-02-03

D3281-3 FLOOR PROTECTOR

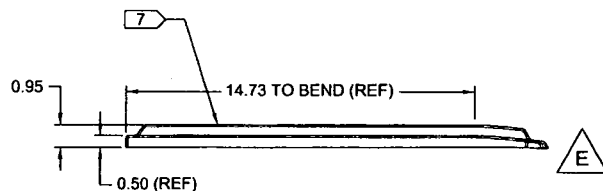
D3281-3 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

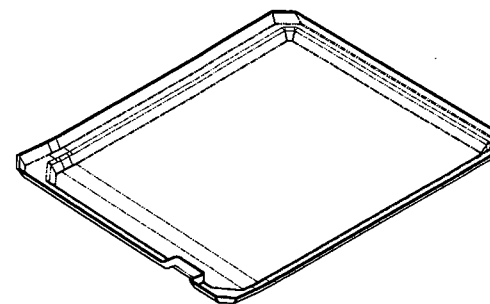
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3281	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1

D

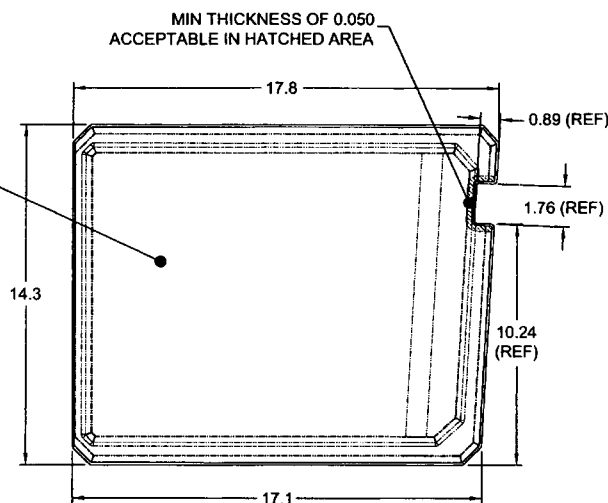


E



C

TEXTURED SURFACE
ON THIS SIDE



B

D3281-4 FLOOR PROTECTOR

WLO 59076

DEO ATTACHED

RELEASED
2010-02-03

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

A

DESIGN	42	DART AEROSPACE LTD	
DRAWN	102	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. E
MFG. APPR.	h	D3281	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	FLOOR PROTECTOR	NTS
DATE	10.01.05	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>jk</i>	MFG. APPR. <i>jk</i>	APPROVED <i>jk</i>	DE APPR. <i>jk</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25	DATE 10.02.25	DATE 10.02.25	

PURPOSE

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

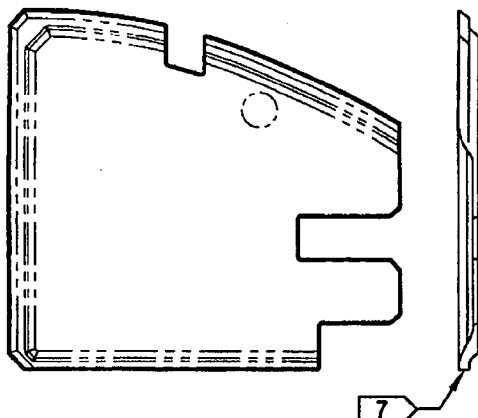
CHANGE

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

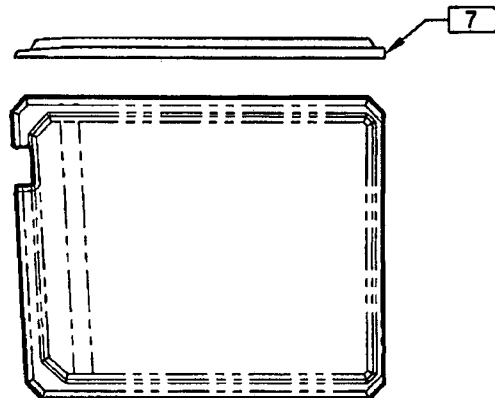
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.
FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb
D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



**D3281-1L08 FLOOR PROTECTOR (SHOWN)
D3281-2L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING**



**D3281-3L08 FLOOR PROTECTOR (SHOWN)
D3281-4L08 FLOOR PRETECTOR (OPPOSITE)
LOCATION OF ENGRAVING**

RELEASED
2010-02-26
And